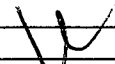
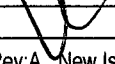


Date: Thursday, 04/01/2007 11:03:00 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLADE FITTING
Job Number : 30111	
Estimate Number : 12299	
P.O. Number : N/A	Part Number : D3488041
This Issue : 04/01/2007 S.O. No. : N/A	Drawing Number : D3488 / DSK101
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B / D
Previous Run : 29432	Material : N/A
Written By : 	Due Date : 30/01/2007 Qty: 12 Um: Each
Checked & Approved By : 	
Comment : Est Rev:A New Issue 06-02-28 JLM Est Rev:B As per Rev B 06-03-30 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6103003	alum billet
-----	----------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
Alluminum Round Billet D6103-003
Batch: 30170

BG 07.01.14 12

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE
1-Turn as per Dwg DSK 101 & Folio FA625

2-Deburr

BG 07.01.14 12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BG 07.01.14 12

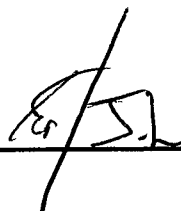

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA625 & Dwg D3488

2-Deburr

SL 07/02/17  

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07/02/17	4	- 1 part scrap - part was placed on wrong side in jig - operator error	J.L 07/02/17	Scrap: destroy No replace	J.L 07/02/17	07/02/19	Q51012	07/02/19

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/02/22

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 04/01/2007 11:03:00 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 30111

Part Number: D3488041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL/ER

07/02/17

(11)

6.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS

07/02/17

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS/ER

07-02-19

(11)

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MS/ER

07/02/20

(11X)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Q.M.

07/02/21

(11)

10.0 ALS71032225 INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 ALS7-1032-225 Insert

M19393

Q.M.

07/02/21

(11)

11.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg D3488

Q.M.

07/02/21

(11)

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M19393

(11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 07/02/22

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 04/01/2007 11:03:00 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 30111

Part Number: D3488041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FR

a.m

01/02/21

(32)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(11)
207/02/22

Job Completion



U 02-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

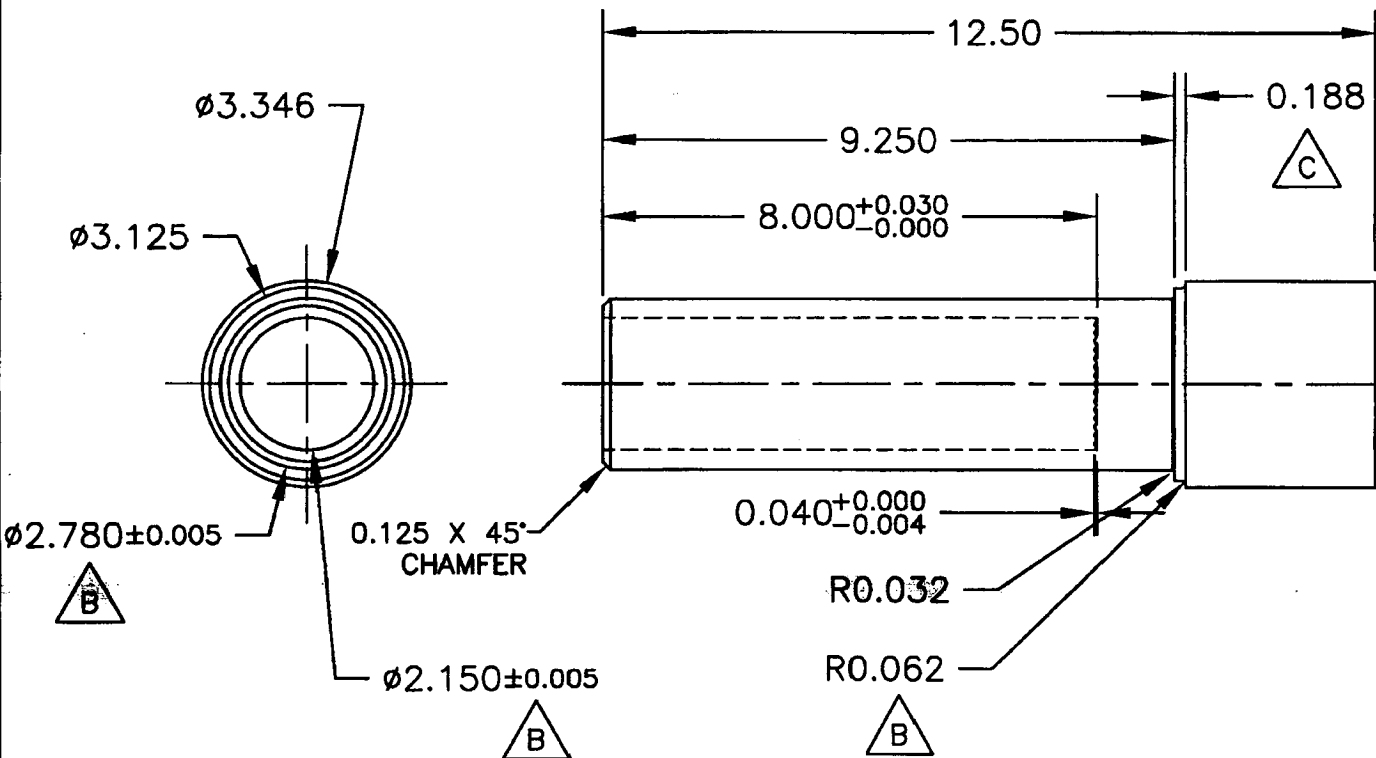
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
04	04	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. D
<i>[Signature]</i>	<i>[Signature]</i>	DSK 101	SHEET 1 OF 1
DATE		TITLE	SCALE
06.05.09		D3488-1/-2 TURNING DETAIL	1:3
A	05.12.21	NEW ISSUE	
B	06.03.02	ADD TOLERANCES AND RADIUS	
C	06.04.17	0.188 WAS 0.125	
D	06.05.09	REMOVE DIAMETER FOR CHAMFER	

**DSK 101**

- 1) MATERIAL: MAKE FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
 - 2) FINISH: NONE
 - 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- W3011*

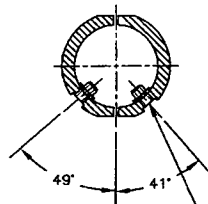
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

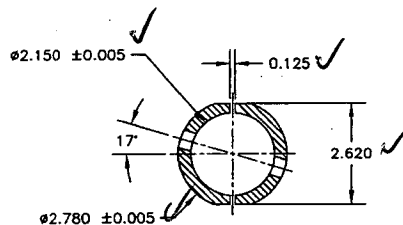
QA: N/C Closed: _____ Date: _____



SECTION B-B

Ø0.297 ✓
C'BORE Ø0.430 x 0.100 ✓
INSTALL ALS4-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)

4



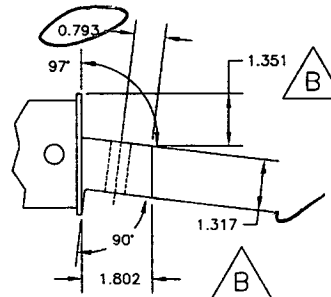
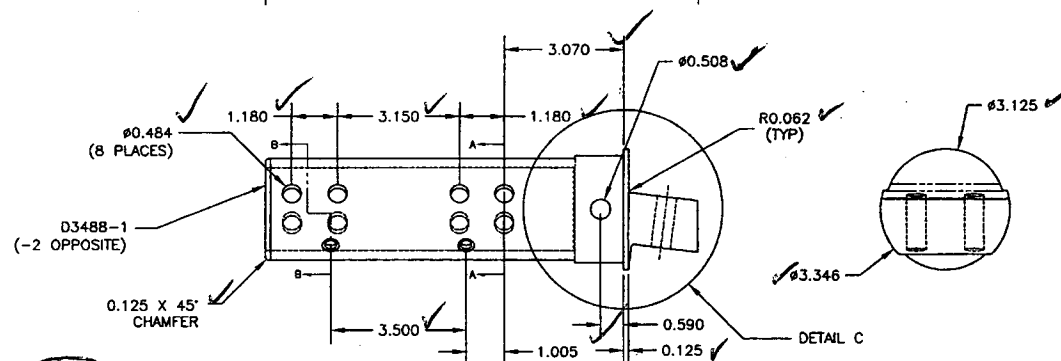
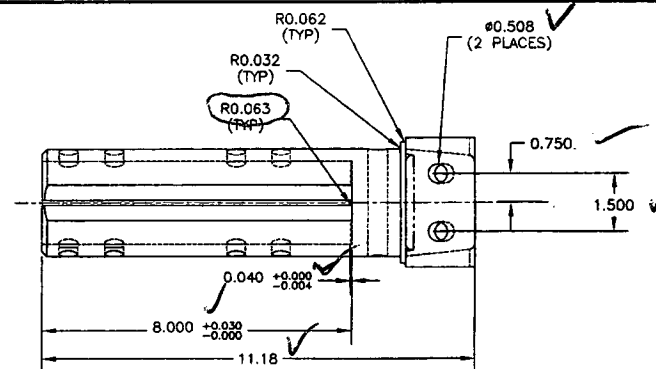
SECTION A-A

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D3488-041	BLADE FITTING ASSEMBLY (LH)
		D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- INSTALL INSERTS AFTER POWDER COAT
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DETAIL C

D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED
06.03.15 PH
PER OS
EIN #784

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	PH	DRAWING NO. D3488
DATE	06.03.15	TITLE BLADE FITTING
		REV. B SHEET 1 OF 1 SCALE 1:3

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11/03/15

DART AEROSPACE LTD		Work Order: 30161
Description: Blade Fitting, LH		Part Number: D3488-1
Inspection Dwg: D3488	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0.125	✓			
2.620	+/-0.010	2.624	✓			
1.351	+/-0.010	1.341	✓		HG	
1.317	+/-0.010	1.316	✓			
90°	+/-0.1°	90°	✓			
1.802	+/-0.010	1.805	✓		HG	
Ø0.508	+0.006/-0.001	0.509	✓			
R0.062	+/-0.010	0.062	✓			
1.500	+/-0.010	1.497	✓			
8.000	+0.030/-0.000	8.000	✓			
11.18	+/-0.030	11.174	✓		HG	
Ø0.484	+0.005/-0.001	0.485	✓			
1.180	+/-0.010	1.177	✓			
3.150	+/-0.010	3.149	✓			
3.070	+/-0.010	3.064	✓			
0.590	+/-0.010	0.589	✓			
0.125	+/-0.010	0.129	✓			
1.005	+/-0.010	1.000	✓			
3.500	+/-0.010	3.501	✓			
Ø0.297	+0.005/-0.000	0.299	✓			
Ø0.430	+/-0.010	0.430	✓			
0.100	+/-0.010	0.095	✓			

Measured by: SC/Er	Audited by: J.F.	Prototype Approval:	N/A
Date: 07/02/16	Date: 07/02/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	